



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

000494

646.4003
Job Sheet 186127



Part No: 646.4003

Job Qty: 1 ea

Part Name: AS350 Cable Cutter System Removable Provisions



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/12/18

Job Tracking No:

Due Date: 11/30/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV C1 IPP REV:A 12.12.23 NEW ISSUE DD VERF:JLM IPP REV:B 15.01.08 AS PER DWG REV.B
DD VERF:JLM IPP REV:C 16.01.07 DWG REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/30/18	11/30/18	0.00	0.00	Start Up Stores/Pkg-1		NOV 19 2018
110	Packaging	1 pcs	11/30/18	11/30/18	0.00	0.00	Packaging1-1		NOV 19 2018
120	QC	1 pcs	11/30/18	11/30/18	0.00	0.00	QC4		NOV 19 2018
130	Packaging	1 pcs	11/30/18	11/30/18	0.00	0.00	Packaging3-1		NOV 19 2018
135	DC	1 pcs	11/30/18	11/30/18	0.00	0.00	DC		NOV 19 2018
140	QC21-FG	1 Ea	11/30/18	11/30/18	0.00	0.00	QC21		NOV 19 2018

Part Op 130 - Identify and pack for shipping as per PPP 646.4003 Location: _____
Descriptions: 135 - Photocopy bluefile & type labels per PPP 646.4003

RECEIVED
JAN 10 1964
U.S. AIR FORCE
HONOLULU, HAWAII
83-8

#2. JDS 186127

000496

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
600.0129	VHB Tape	8 ft (8 ea)	90-Start up Operation	5031229
600.0990	Magnabond 6398 Part A Size 112 ml	1 Ea (1 ea)	90-Start up Operation	5121187
600.0991	Magnabond 6398 Part B Size 112 ml	1 Ea (1 ea)	90-Start up Operation	5121188
600.1012	Sealant PR1425B2 (#654 sem)	1 pcs (1 ea)	90-Start up Operation	5119525
600.1013	021200-3M Tape Primer 94 Primer 24216	5 Ea (5 ea)	90-Start up Operation	5119444
646.2910	Deflector	1 Ea (1 ea)	90-Start up Operation	5079498
646.3001	Lower Cable Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	5125414
646.3110	Channel	1 Ea (1 ea)	90-Start up Operation	5117185
646.3301	Upper Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	5104453
646.3510	Strut	1 Ea (1 ea)	90-Start up Operation	5050453
646.3511	Strut	1 Ea (1 ea)	90-Start up Operation	5081639
646.3610	Filler	1 Ea (1 ea)	90-Start up Operation	5092525
646.3711	Clip	1 Ea (1 ea)	90-Start up Operation	5038799
646.3712	Clip	1 Ea (1 ea)	90-Start up Operation	5026726
646.3716	Gauge Bracket	1 Ea (1 ea)	90-Start up Operation	5080290
646.3718	Custom Washer	2 Ea (2 ea)	90-Start up Operation	5038803
646.3811	Radius Block	1 Ea (1 ea)	90-Start up Operation	5070843
646.3910	Shim	4 Ea (4 ea)	90-Start up Operation	5083586
646.3911	Shim	1 Ea (1 ea)	90-Start up Operation	5041250
646.3912	Shim	4 Ea (4 ea)	90-Start up Operation	5076145
646.3913	Shim	1 Ea (1 ea)	90-Start up Operation	5126060
646.9410	Shim	1 Ea (1 ea)	90-Start up Operation	5056998
647.0112	Strut Bracket	2 Ea (2 ea)	90-Start up Operation	5097193
647.7703	Strut Assembly	2 Ea (2 ea)	90-Start up Operation	5118480
650.9201	Eyelet Bracket Assembly	2 Ea (2 ea)	90-Start up Operation	5092170
AN3-11A	Bolt	10 Ea (10 ea)	90-Start up Operation	5098034
AN3-12A	Bolt	2 Ea (2 ea)	90-Start up Operation	5095479
AN3-13A	Bolt	1 Ea (1 ea)	90-Start up Operation	5098032
AN3-4A	Bolt	6 Ea (6 ea)	90-Start up Operation	5060063
AN3-5A	Bolt	2 Ea (2 ea)	90-Start up Operation	5119258
AN3-6A	Bolt	2 Ea (2 ea)	90-Start up Operation	5103950
AN316C4R	Nut, Jam	2 Ea (2 ea)	90-Start up Operation	5080637
AN44-5A	Eyebolt	2 Ea (2 ea)	90-Start up Operation	5104032
AN4C7A	Bolt	2 Ea (2 ea)	90-Start up Operation	5095478
AN665-34R	Clevis	2 Ea (2 ea)	90-Start up Operation	5107789
MS20426AD5-7	Rivet	2 Ea (2 ea)	90-Start up Operation	5153848
MS21042-08	Use Ms21042L08	2 Ea (2 ea)	90-Start up Operation	5100909
MS21042-3 L3	Nut	2 Ea (2 ea)	90-Start up Operation	5108577
MS21042L3	Nut	53 Ea (53 ea)	90-Start up Operation	5094592
MS21042L4	Nut	2 Ea (2 ea)	90-Start up Operation	5109236
MS24693-C278	Screw	5 Ea (5 ea)	90-Start up Operation	5065341
MS24694-S51	Screw	5 Ea (5 ea)	90-Start up Operation	5004859
MS24694-S54	Screw	2 Ea (2 ea)	90-Start up Operation	5118346
MS24694-S55	Screw	3 Ea (3 ea)	90-Start up Operation	5099526
MS27039-08-13	Screw	2 Ea (2 ea)	90-Start up Operation	5016508
MS27039-1-12	Screw	6 Ea (6 ea)	90-Start up Operation	5006971
MS27039-1-16	Screw	24 Ea (24 ea)	90-Start up Operation	5049833x17
MS27039-1-19	Screw	22 Ea (22 ea)	90-Start up Operation	5071413
MS27039-1-20	Screw	2 Ea (2 ea)	90-Start up Operation	5094554
MS27039-1-21	Screw	4 Ea (4 ea)	90-Start up Operation	5037684x2
NAS1149F0332P	Washer	120 Ea (120 ea)	90-Start up Operation	5109991
NAS1149F0432P	Washer	4 Ea (4 ea)	90-Start up Operation	5123456
NAS1149FN832P	Washer	4 Ea (4 ea)	90-Start up Operation	5107796

Exp 10/19
Exp. 4/19



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S128861



Part: 646.4003

Job No: 186127

Serial No/Batch: S128861

Revision: C1

Inspector:

Exp Date:

Instructions: FAA STC SR02180LA 08/12/16, TC STC SH09-10 Issue 1, BRAZIL

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	600.0129	8	224	0
	600.0990	1	11	0
	600.0991	1	11	0
	600.1012	1	24	0
	600.1013	5	67	0
	646.2910	1	24	0
	646.3001	1	13	0
	646.3110	1	11	0
	646.3301	1	11	0
	646.3510	1	16	0
	646.3511	1	21	0
	646.3610	1	21	0
	646.3711	1	31	0
	646.3712	1	19	0
	646.3716	1	37	0
	646.3718	2	38	0
	646.3811	1	28	0
	646.3910	4	55	0
	646.3911	1	20	0
	646.3912	4	53	0
	646.3913	1	36	0
	646.9410	1	98	0
	647.0112	2	82	0
	647.7703	2	10	0
	650.9201	2	31	0
	AN3-11A	10	145	0
	AN3-12A	2	90	0
	AN3-13A	1	96	0
	AN3-4A	6	344	0
	AN3-5A	2	314	0
	AN3-6A	2	178	0
	AN316C4R	2	33	0
	AN44-5A	2	27	0
	AN4C7A	2	139	0
	AN665-34R	2	25	0
	MS20426AD5-7	2	988	0
	MS21042-08	2	1	0
	MS21042-3	2	214	0
	MS21042L3	53	2,015	0
	MS21042L4	2	2,292	0
	MS24693-C278	5	139	0
	MS24694-S51	5	295	0
	MS24694-S54	2	406	0
	MS24694-S55	3	98	0
	MS27039-08-13	2	578	0
	MS27039-1-12	6	246	0
	MS27039-1-16	24	573	0
	MS27039-1-19	22	329	0
	MS27039-1-20	2	99	0
	MS27039-1-21	4	110	0
	NAS1149F0332P	120	1,801	0
	NAS1149F0432P	4	706	0
	NAS1149FN832P	4	2,479	0

Part Specifications

Specifications could not be found.

REFERENCE ONLY

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES DBA DART AEROSPACE. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE EXPLICIT WRITTEN PERMISSION OF APICAL INDUSTRIES DBA DART AEROSPACE IS PROHIBITED.

NOTES:

1 AFTER INSTALLATION, APPLY F/N 54 A/R TO FILL GAPS AND FILLET EDGES.

2 INSTALL F/N 14 WITH F/N 52 & 53.

3 3M VHB ADHESIVE TAPE .025" THICK X .50" WIDE
VENDOR: MCMASTER-CARR P/N 75935A651.

4 3M TAPE PRIMER 94, APPLY TO BOTH SURFACES A/R BEFORE TAPE.
VENDOR: R.S. HUGHES P/N 021200-24216.

5 REUSE FASTENERS FROM F/N 1.

6 USE WASHERS A/R AS SHIMS TO OBTAIN BEST FITMENT.

7 AT CUSTOMERS OPTION, INSTALL F/N 65 BY MATCH DRILLING ON TO F/N 1.

8 INSTALL SHIM IF OEM PROVISIONS ARE INSTALLED ON AIRCRAFT. REMOVE SHIM LAYERS TO ACHIEVE CORRECT SIZE. MATCH DRILL HOLES. USE F/N 78 SCREW IN PLACE OF F/N 17 SCREW.

9 NEWER INSTALLATIONS ON AIRCRAFT WITH UPDATED CANOPY MAY REQUIRE DIFFERENT LENGTH SCREWS. USE F/N 62 TO REPLACE F/N 44 & F/N 26 IN PLACE OF F/N 41 WHEN NECESSARY.

UNINCORPORATED ECN(s)

05304

REFERENCE ONLY

5	5	5	78	601.3875	SCREW	MS27039-1-16				
1	1	1	77	646.9410	SHIM	MS27039-1-16				
	4	4	76	601.2764	WASHER	MS21042-08				
	2	2	75	601.2973	LOCKNUT	MS27039-0B13				
	2	2	74	601.2988	SCREW	MS21042-5				
	2	2	73	601.2943	LOCKNUT	AN516CAR				
	2	2	72	601.3128	NUT	MS21042-6				
	2	2	71	601.3209	LOCKNUT	MS2149D452P				
	4	4	70	601.2638	WASHER	AN4C7A				
	2	2	69	601.2669	BOLT	AN565-34P				
	2	2	68	601.3119	CLEVIS	AN44-5A				
	2	2	67	601.3121	EYE BOLT					
	2	2	66	650.9201	EYE BRACKET ASSY					
REF	REF	REF	65	647.5701	GPS MOUNT KIT					
		2	64	601.3151	WASHER	MS2149D3M3P				
		2	63	601.2911	SCREW	MS2464553				
	24	24	62	601.2637	SCREW	MS27039-1-16				
2	2	2	61	601.2763	BOLT	AN3-12A				
	1	1	60	646.3913	SHIM					
	4	4	59	646.3912	SHIM					
	1	1	58	646.3911	SHIM					
	4	4	57	646.3910	SHIM					
	5	5	56	600.1013	PRIMER					
	8 FT	8 FT	55	600.0129	VHB TAPE					
	1	1	54	600.1012	SEALANT	PR-1425 CLASS-B				
	1	1	53	600.0991	MAGNOBOND 639B PART B					
	1	1	52	600.0990	MAGNOBOND 639B PART A					
6	10	10	51	601.2826	BOLT	AN3-11A				
		2	50	646.3814	WIPER BRACKET					
		2	49	601.2910	SCREW	MS27039-1-18				
	2		48	601.1365	SCREW	MS27039-1-10				
	2		47	646.3719	DOUBLER					
	2		46	646.3718	CUSTOM WASHER					
	1		45	646.3717	DOUBLER					
	22	2	44	601.1948	SCREW	MS27039-1-19				
	2		43	601.1952	SCREW	MS27039-1-20				
	4		42	601.1956	SCREW	MS27039-1-21				
4006	4005	4004	4003	4002	4001	FIND #	PART #	DESCRIPTION	MATL	SPEC.

REV.	DESCRIPTION	DATE	APPROVED
A	INCORPORATED ECN 02199, 02201, 02216 & 02245	02/08/2010	P. BRAVO
B	INCORPORATED ECN 02044, 02079 & 04731	11/04/2014	P. BRAVO
C	INCORPORATED ECN 03098	09/09/2015	P. BRAVO

		2	2	41	601.2829	SCREW	MS2449-555A			
		2	2	40	601.2831	RIVET	MS20426AD5-7			
		1	1	39	646.3716	GAUGE BRACKET				
		6	6	38	601.1953	SCREW	MS27039-1-12			
	2	2	2	37	646.3715	STRUT DOUBLER				
				36	601.2824	BOLT	AN3-5A			
12	36			35	601.2277	RIVET	CCR2448-3-02			
6	18			34	600.0795	NUTPLATE	MS21047-3			
3	3			33	601.2565	RIVET	MS20470AD5-7			
1	1			32	646.3813	STRUT BRACKET				
4	4			31	601.2822	BOLT	AN3-3A			
2	2			30	646.3812	GUSSET BRACKET				
8	8			29	601.2564	RIVET	MS20470AD5-6			
1	1			28	646.3714	GUSSET				
	1	1		27	646.3610	FILLER				
	3	3		26	601.2830	SCREW	MS2449-555B			
	2	2		25	601.2825	BOLT	AN3-6A			
	1	1		24	646.3811	RADIUS BLOCK				
	1	1		23	646.3712	CLIP				
	1	1		22	646.3711	CLIP				
	8	8		21	601.2832	RIVET	MS20470AD5-5.5			
14	14			20	601.2020	RIVET	CR3213-5-3			
4	6	4	6	10	601.2823	BOLT	AN3-4A			
	1	1		18	601.2827	BOLT	AN3-13A			
	5	5		17	601.2912	SCREW	MS2449-5551			
	1	1		16	646.3713	GUSSET				
	1	1		15	646.3210	SUPPORT				
		1		14	646.3710	DOUBLER				
	1	1		13	646.3110	CHANNEL				
14	10	8	53	6	61	12	601.1624	LOCKNUT	MS21042-3	
16	32	18	120	16	144	11	601.1607	WASHER	NA51149F0332P	
						10	646.3410	LH WIPER DEFLECTOR		
						9	646.3411	RH WIPER DEFLECTOR		
			2	2	8		647.7703	STRUT ASSY		
			2	2	7		647.0112	STRUT BRACKET		
	1		1	1	6		646.3511	STRUT		
	1		1	1	5		646.3510	STRUT		
2		2		2	4		646.3810	BRACKET		
			1	1	3		646.2910	DEFLECTOR		
	1		1	1	2		646.3001	LOWER CUTTER ASSY		
			1	1	1		646.3301	UPPER CUTTER ASSY		
X							646.4006	LOWER CUTTER FIXED PROVISIONS		
	X						646.4005	LOWER CUTTER REMOVABLE PROVISIONS		
		X					646.4004	FIXED PROVISIONS KIT		
			X				646.4003	CABLE CUTTERS KIT (WITHOUT FIXED PROVISIONS)		
				X			646.4002	AS350 WIPER DEFLECTOR KIT		
					X		646.4001	AS350 CABLE CUTTERS KIT		
4006	4005	4004	4003	4002	4001	FIND #	PART #	DESCRIPTION	MATL	SPEC.

QTY		NEXT ASSY (S)		ORIGINAL DATE (M/D/YR) 08-27-08 DRAWN BY J. CROCKER I. HUFF P. BRAVO DRAWING APPROVAL P. BRAVO 08/27/08 CONTRACT NO.		DART 3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760) 724-5300 APICAL INDUSTRIES INC. DBA DART AEROSPACE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.010 3 PLACE DECIMALS ±.005 ANGLES ±.5°						AS350 CABLE CUTTERS KIT SIZE B CAGE CODE 07M16 DWG. NO. 646.4000 SCALE NONE SHEET 1 OF 5	

1911

1911